Date: P.O. Number This Issue Previous Run

Thursday, 6/21/2007 2:34:45 PM

Kim Johnston

Process Sheet

Customer

Job Number

: CU-DAR001 Dart Helicopters Services : 33083

Estimate Number

: 10327 : 6/21/2007

S.O. No. : NA

Prsht Rev. First Issue

: MACHINED PARTS Type

Part Number **Drawing Number**

Drawing Name

Project Number

Drawing Revision Material Due Date

D2741 REV C : N/A

: D2741

: BLADE

Alu: : 7/15/2007

Each

Written By

Checked & Approved By

Comment

: Est Rev.

00.11.15

Removed P/O turning - in house

process EC

Est Rev: E

As Per Rev C 06-03-20

JLM

Est Rev: F

06.04.20 Added grinding after heat treating E

Additional Product

Job Number:



Seq. #: .

Description:

4130 Bar 0.5 x 3.0"

M4130NB0500X03000



Comment: Qty: 1.2118 f(s)/Unit Total:

36.3542 f(s)

, 4130 BAR 0.5 x 3.0"

Material: 4130 steel bar 0.50" x 3.00"

Batch: M 104 884×12

7 JF 07/09/24

BAND SAW



Comment: BAND SAW

Cut blanks 13.850" long +0.063" -0.000"

3.0

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio FA108

Page 1

Form: rorocess

Dart Ae	rospac	e Ltd								
W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PR	OCEDURE CHAN	IGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	_ NCR:	Yes N	o DQ A	\:	_ Date: _	
			<i>a</i> .,	• 1	(QA: N/C	Closed	l:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)				
		Description of NC	(Corrective Action Sec	tion B	 	Verific	ation	Ammuouol	Ammanal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Approval Chief Eng	Approval QC Inspector
					4.					
			:					-		

NOTE: Date & initial all entries

Date: Thursday, +6/21/2007 2:34:45 PM Ùser: Kim Johnston **Process Sheet** Drawing Name: BLADE Customer: CU-DAR001 Dart Helicopters Services Job Number: 33083 Part Number: D2741 Job Number: Description: Seq. #: Machine Or Operation: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 5.0 QC8 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 6.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 SAD 02-09-27 1-Deburr_{*} 2-Bend per Dwg D2741 INSPECT WORK TO CURRENT STEP 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP OUTSIDE SERV.30 OUTSIDE SERVICES-MACH 8.0 Comment: Sub-Contracting PURCHASING C207109/28 Issue P/O: Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (30-40 HRC) Min. Yield Tensile Strength = 141 ksi Test report or Certification required PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Receive and Inspect for transit damage Ensure Test report or Certification attached INSPECT WO QC5 10.0 Comment: INSPECT WORK TO CURRENT STEP SMALL & MEDIUM FAB RESOURCE 1 11.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Grind off carbon deposits

	Dart	Aeros	pace	Ltd
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Dart Ae	rospace	e Ltd								
W/O:			٧	VORK ORDER C	HANGES					
DATE	STEP	PRO	CEDURE CI	HANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				, -						
Part No	•	PAR #:	Fault Ca	tegory:	NCI	R: Yes (NO DQ	4: <u>1</u>	Date: <u>&</u>	Holale
									_ Date: _	
NCR:		٧	VORK OR	DER NON-CONF	ORMANCE	(NCR)			
DATE	0.755	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Desci Chief Eng	ription	Sign & Date	Section		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Thursday, 6/21/2007 2:34:45 PM Date: User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BLADE Part Number: D2741 Job Number: 33083 Job Number: Description: Seq. #: Machine Or Operation: POWDER COATING POWDER COATING 12.0 105068 Comment: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.2) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 13.0 **300** POWDER COAT/CHEMICAL CONVERSION 14.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 15.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Utronb Job Completion

Dart Aerospace Ltd

Dail Ac	Ospace	5 LIU	,						
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	_ Fault Categ	jory:	_ NCR: Yes	No DQ	A:	_ Date: _	
		•			QA: I	N/C Close	d:	Date:	
NCR:		V	ORK ORDE	R NON-CONFORM	ANCE (NCI	₹)	•	· ·	
		Description of NC		Corrective Action Sect	ion B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE L	TD		Work Order:	33083
			Dord Number	D2741
Description: Blade		· · · · · · · · · · · · · · · · · · ·	Part Number:	<i>UZ1</i> 41
Inspection Dwg: D2741	Rev: C			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First	Article		Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	//_	, tojout	Inspection	
1.500	+/-0.010	1.500				
0.715	+/-0.010	·715	/			
Ø0.516	+0.008/-0.001	.519				
2.000	+/-0.010	2.001				
13.750	+/-0.010	13.751				
Ø1.06 x 0.150	+0.012/-0.001 x +/-0.010	1.059x.150				
2.930	+/-0.010	2,931	//			
0.375	+/-0.010	-380	/			
0.25 x 0.25	+/-0.030	.25x.25	<i>\</i>			
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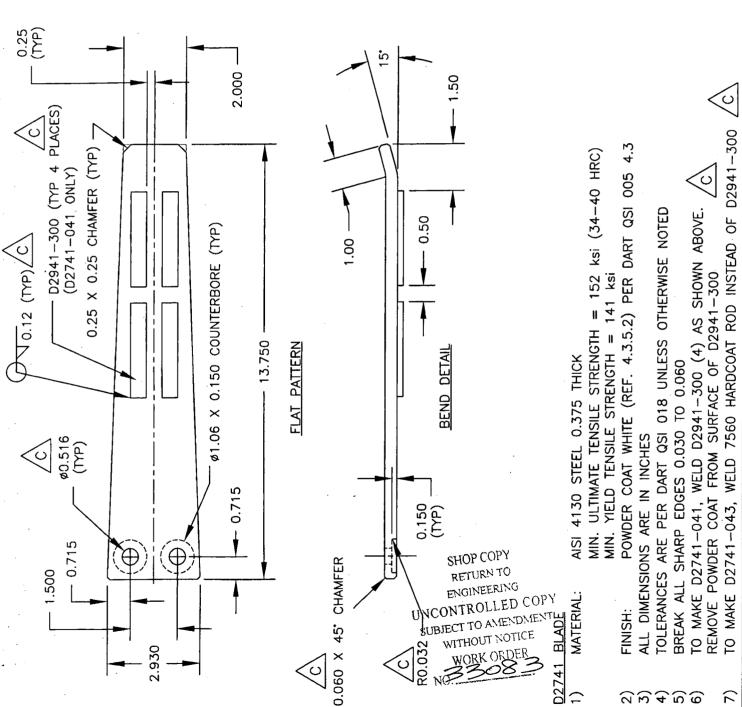
8				
Measured by:	ブル	Audited by:	Prototype Appro	val: N/A
Date:	07/09/25	Date: 62.00urs	D	ate: N/A

Rev	Date	Change	Revised by	Approved
Α	03.12.22	New Issue	KJ/RF	1
В	06.03.09	Revised per Rev. C	KJ/JLM	
			7 (1)	



			· · · · · · · · · · · · · · · · · · ·
DESIG	N PH	DRAWN BY	DART AEROSPACE USA, INC.
CHECI	KED	APPROVED	DRAWING NO. REV. C D2741 SHEET 1 OF 1
DATE 06.0	01.12		BLADE SCALE
Α		98.04.16	NEW ISSUE
В		98.09.01	CHANGE C'SINK TO C'BORE
			LARCER HOLE ADD RADIUS AND CHAMFER

Α	98.04.16	NEW ISSUE
В	98.09.01	CHANGE C'SINK TO C'BORE
С	06.01.12	LARGER HOLE,ADD RADIUS AND CHAMFER ADD -041/-043 OPTIONS



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PACKING SLIP

OAK 91545-1

BILL TO:

HEAD CHICK 1371 SPEERS ROAD, OAKVILLE, ONTARIO CANADA L6L 2X5 TEL: (903) 827-4171 FAX: (905) 827-7489

QUEBEC DIVISION 7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC CANADA H4S 1C5 Tel: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

10/17/2007

MM / DD / YYYY

1

PAGE:

1DAR01

KEA 1K7

DIRT AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
10/17/2007	FED EX 15179324-0	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
214742		COD

	PAFT NO	DESCRIPTION	MOU	QTY ORDERED	QTY SHIPPED	B/O QTY
D27	41.	B33083	EA	30	30	(
. To the same of t						
		ions: Procedure: 4161				
		D2741 TO 152 KSI MINIMUM ED PER ASTM E-18, HRC: 34-40				
	F HARDNESS TEST	ED PER ASIM E-10, HRC: 34-40				
MALE	inami. 4100				.'	
<u> </u>						**
MC		MINIMUM CHARGE		1	1	
		105 LBS @ \$2.26/LB				
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No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.







RELEASE NOTE

GST No.: R105468102

OAK 91545-1

SILL TO:

HEAD OF THE 1371 Speirs Road, Oakville, Ontario CANADA L6L 2X5 TEL. (905 827-4171 FAX: (905) 827-7489 2009 WYECROFT ROAD, UNIT B OAKVILLE, ONTARIO CANADA L6I 6J4

7450 RUE VÉRITÉ STREET, ST. LAURENT. QUÉBEC CANADA H4S 1C5 Tel: (514) 334-4240 FAX: (514) 334-6269 Tel. (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION

10/17/2007

MM / DD / YYYY

PAGE:

1

1DAR01

DART AEROSPACE LTD.

1270 ABERDEEN ST. HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.

1270 ABERDEEN ST.

HAWKESBURY, ON

K6A 1K7

K6A 1K7

. DATE SHIPPED	SHIP VIA	F.O.B.	
10/17/2007 C JSTOMER P/O No.	FED EX 15179324-0	ORIGIN	
	JOB №.	TERMS	
214742		COD	

PART No. DESCRIPTION	lucasi U	TY QTY RD SHPD	TEST RESULTS		

72741 /

B33083

MATERIAL: 4130 ,

Process Specifications:_ HARDENED PER DWG. D2741 TO 152

100% HARDNESS TESTED PER ASTM E-18, HRC: 34-40

Procedure: 4161

NSI MINIMUM

30 30

100% HARDNESS

hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant hereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

uthorized Q.C. Inspector

Accredited 6 HEAT TREATING

